

Ship May 8

Work Order ID 129723

129723

Page 1

February-23-15 10:18:07 AM

Item ID: D2362-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 350 Pre-Flite Step
 Start Date: 2/23/15 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-02-24 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2362	Rev E1

100 Weld per dwg A/R Aluminum rod Batch M127865 0.00
 Large Fab.
 Memo 0.00
 Cut D2244 extrusion 3.75" long
 Deburr D2244-3.75
 Weld D2244-3.75 to D2362-7 as per Dwg D2362and QSI 004

> DP 15-5-5
BE 15-05-05

105 QC6- Inspect dimensions to drawing 0.00
 105
 QC Memo 0.00
 Quality Control

② 15-05-05 PD

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 110
 QC Memo 0.00
 Quality Control

② 15-05-05 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
120	<i>M 131545.</i>					<i>2</i>	<i>0</i>	<i>15.5.6.</i>	<i>23 34 9-89</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>10:45.</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>11:15.</i>								
130	QC3- Inspect Part Finish	0.00							
130						<i>2x</i>	<i>0</i>	<i>15/05/06</i>	<i>DAS 15 9-89</i>
QC	Memo	0.00							
Quality Control									
140		0.00							
140	HandFinishing					<i>2x</i>	<i>0</i>	<i>15/05/06</i>	
HandFinish	Memo	0.00							
Hand Finishing	Mask bracket and apply black anti-skid paint as per QSI 005 4.4								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:18:06 AM

Page 1

Work Order ID: 129723

129723

Parent Item: D2362-041

D2362-041

Parent Item Name: 350 Pre-Flite Step

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C00.06.26Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116

Manufactured

No

100

Each

171.0000

1

2

D2244-116

STEP EXTRUSION

**

Location

Loc Qty

Loc Code

HALL

138

117818

138

WA003

32.9999632

104940

33

D2362-7

Manufactured

No

100

Each

4.0000

1

2

D2362-7

Support Bracket

**

Location

Loc Qty

Loc Code

ST537

4

127800

4

Handwritten notes and signatures:

- Signature: [Signature]
- Text: 15-5-5
- Text: 2.68
- Text: 2
- Text: 15-5-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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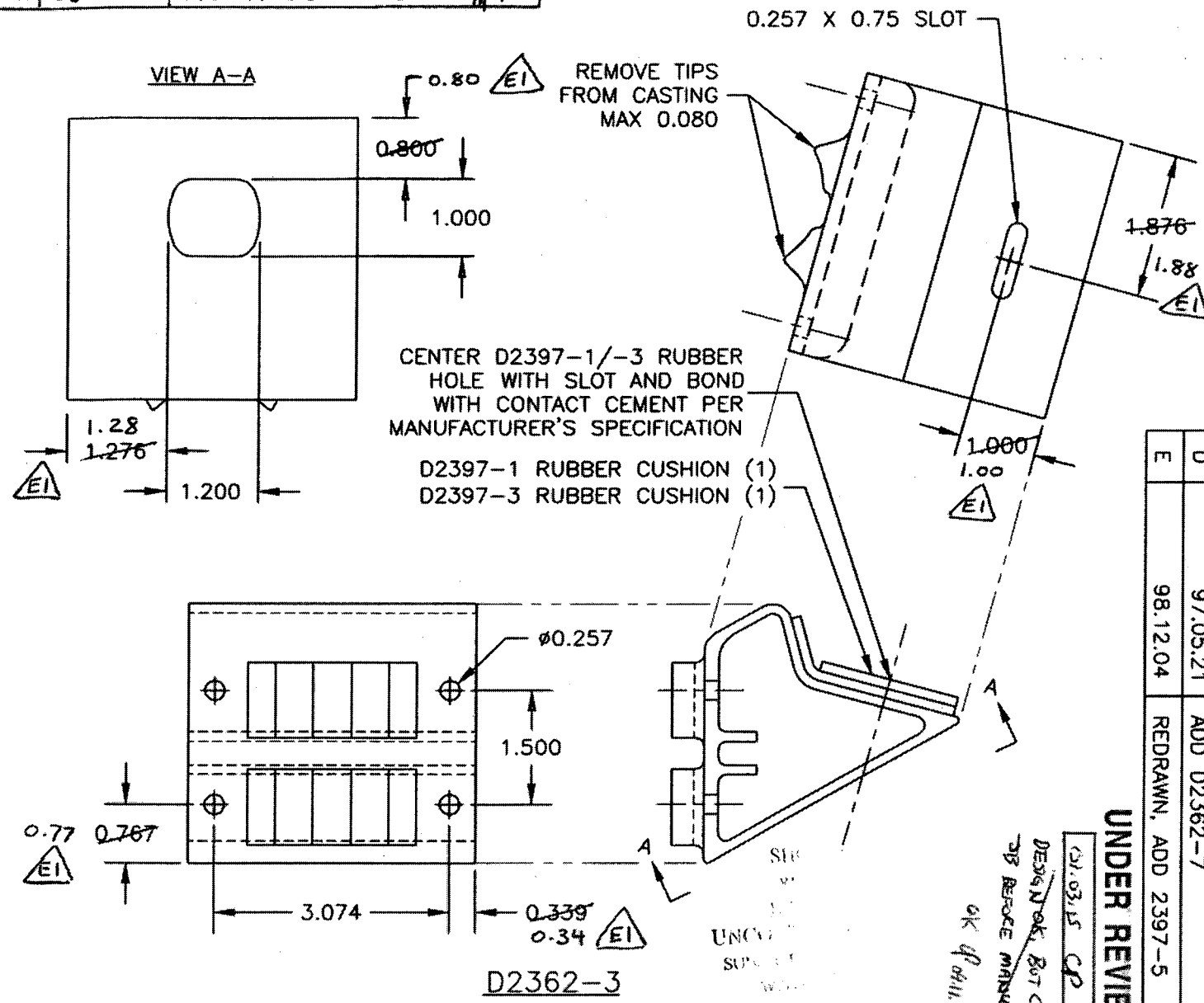
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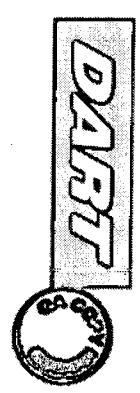
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

EI 03.10.07 TOLERANCE CHANGE ~~RF~~



RELEASED
98.12.14 KE



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW		HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	<i>[Signature]</i>	D2362
DATE	TITLE	SHEET 1 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE
		1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

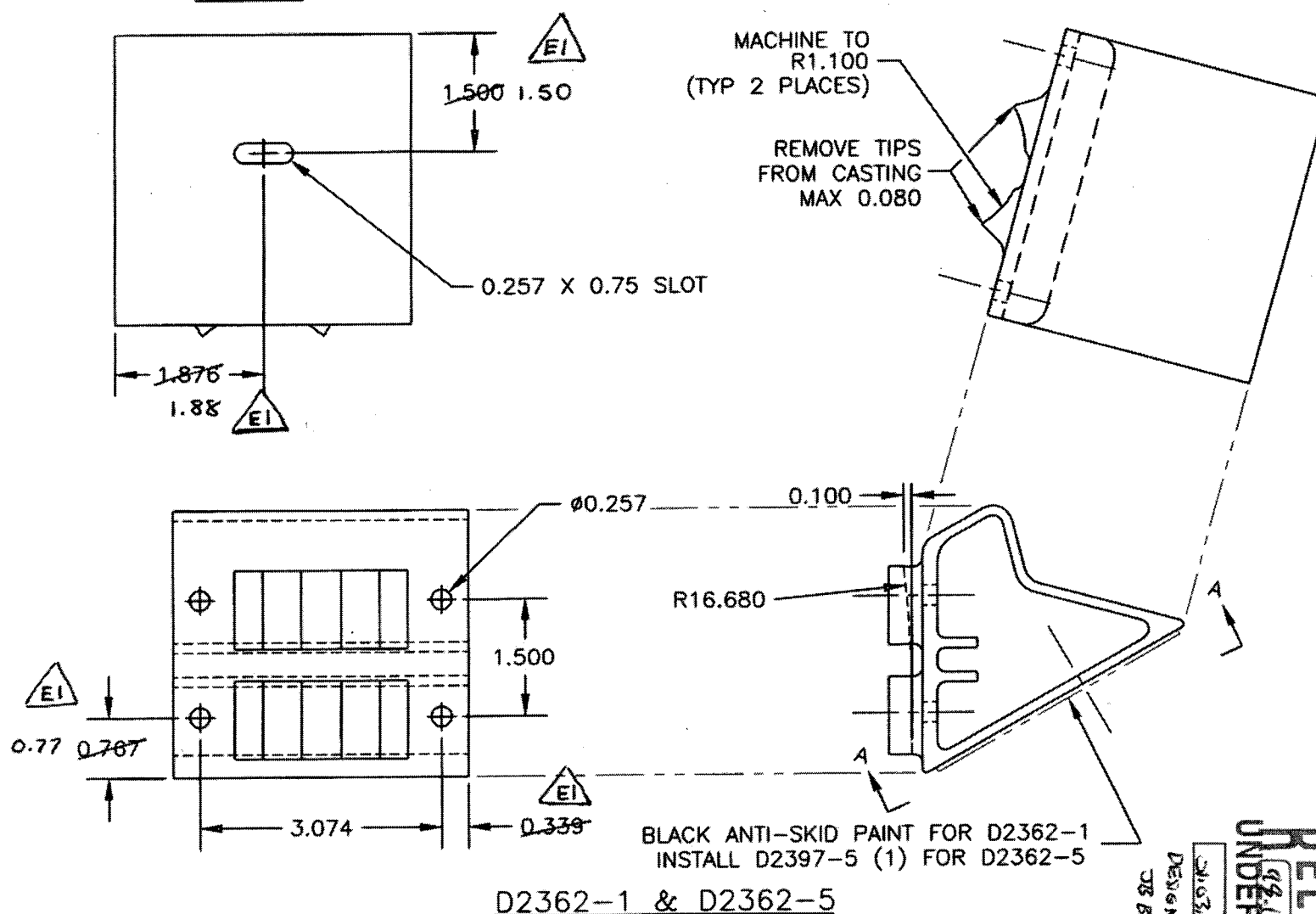
01.03.15 CP

DESIGN OK, BUT CHECK WITH
OR BEFORE MANUFACTURE
OK 14/11/09

129723
MLJ
1502-24

NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

VIEW A-A



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

QA COPY ISSUED

DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	CP	HAWKSBURY, ONTARIO, CANADA
DATE	98.12.04	TITLE	D2362	REV. E
			STEP SUPPORT BRACKET	SHEET 2 OF 3
				SCALE 1:2

RELEASED
98.12.14
UNDER REVIEW

DESIGNED BY
D2362-5
OK 98.12.04

D2362-041 (SHOWN)

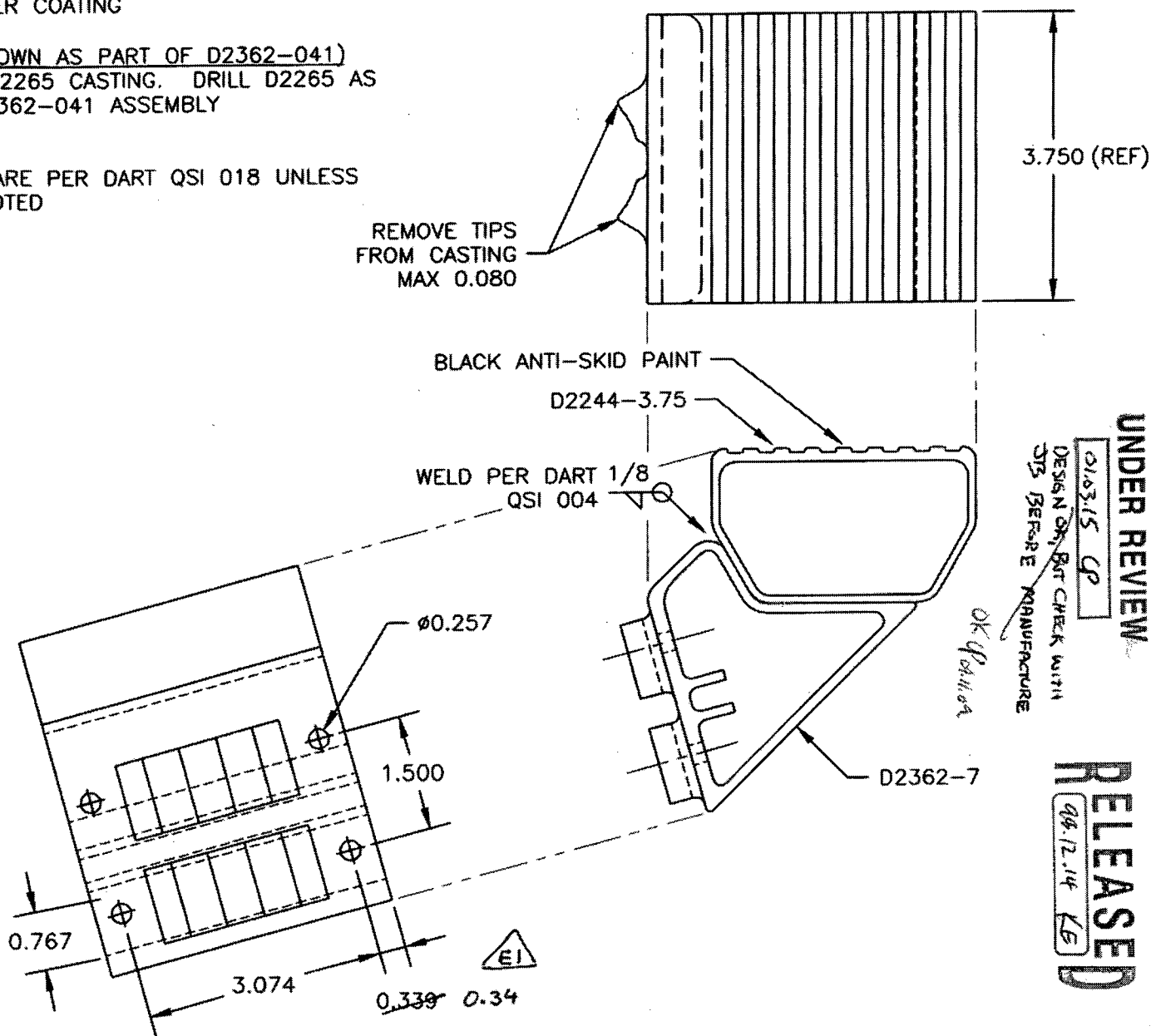
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	MM	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	TITLE	STEP SUPPORT BRACKET	SCALE
				1:2

UNDER REVIEW

0103/15 CP
DESIGN OK, BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
98.12.14 KE